

Work Order ID 71509

Tuesday, July 05, 2011 10:17:11 AM



Page 2

Item ID: D3437-043

Accept



Setup Start



Revision ID:

Item Name: Aft Strut Assembly

Stop



Start Date: 7/5/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

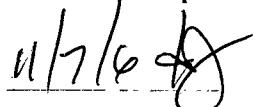
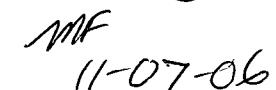
Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Picklist Print

Tuesday, July 05, 2011 10:17:08 AM

Page 1

Work Order ID: 71509



Parent Item: D3437-043



Parent Item Name: Aft Strut Assembly

Start Date: 7/5/2011

Required Date: 7/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A1105.05.200 New Issue IKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|--------------------|--------|
| AN960C516 | | Purchased | No | | | 100 | Each | 39.0000 | 2 | 8 | | <i>EP 11/07/05</i> | |
| WASHER | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | <u>8</u> | |
| | | | | ST347 | | | 39 | | | | | | |
| | | | | | 102842 | | 39 | | | | | | |
| D3437-1 | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 4 | | <i>EP 11/07/05</i> | |
| Foot | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | <u>4</u> | |
| | | | | ST508 | | | 11 | | | | | | |
| | | | | | 46046 | | 11 | | | | | | |
| D3437-3 | | Manufactured | No | | | 100 | Each | 37.0000 | 1 | 4 | | <i>EP 11/07/05</i> | |
| Clip | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | <u>4</u> | |
| | | | | ST508 | | | 37 | | | | | | |
| | | | | | 43175 | | 37 | | | | | | |
| D3437-9 | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 4 | | <i>EP 11/07/05</i> | |
| Eyebolt | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | <u>4</u> | |
| | | | | ST508 | | | 6 | | | | | | |
| | | | | | 44790 | | 6 | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 05, 2011 10:17:08 AM

Page 2

Work Order ID: 71509



Parent Item: D3437-043



Parent Item Name: Aft Strut Assembly

Start Date: 7/5/2011

Required Date: 7/12/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-5



Purchased

No

100

Each

587.0000

1

4



Nut

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FG | 20 | _____ |
| 101418 | 20 | _____ |
| ST301 | 467 | 4 |
| 112314 | 367 | _____ |
| 116548 | 100 | _____ |
| ST314 | 100 | _____ |
| 118159 | 100 | _____ |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

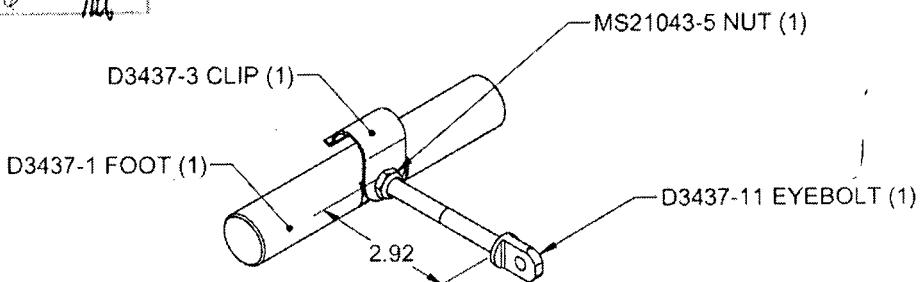
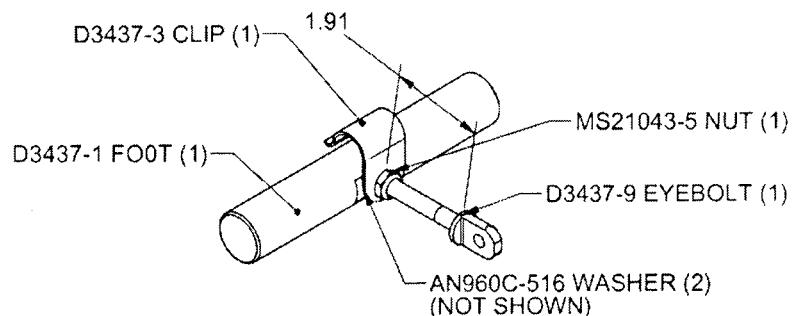
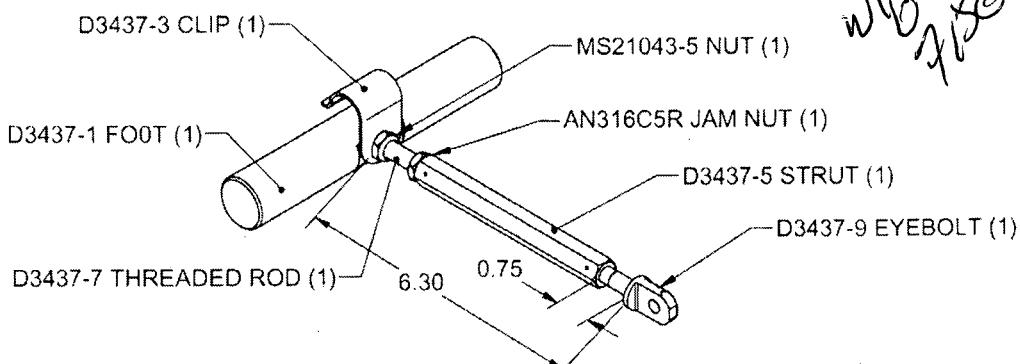
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>HH</i> | APPROVED <i>HH</i> | DRAWING NO. D3437 | REV. B SHEET 1 OF 4 |
| DATE 05.08.11 | | TITLE AFT STRUT ASSEMBLY | SCALE 1:2 |
| A | 05.04.29 | NEW ISSUE | |
| B | 05.08.11 | UPDATE D3437-5/-9/-11 DIMENSIONS | |

RE-CHASED

05.08.16 *HH***D3437-041 AFT STRUT ASSEMBLY****D3437-043 AFT STRUT ASSEMBLY****D3437-045 AFT STRUT ASSEMBLY**

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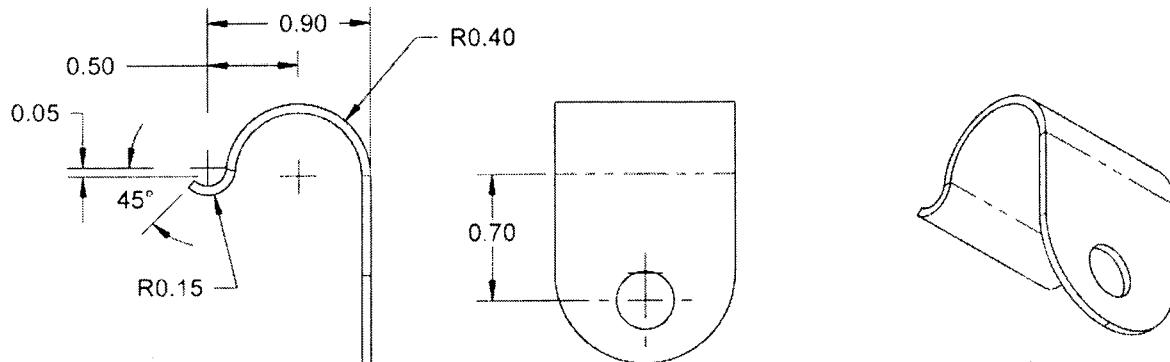
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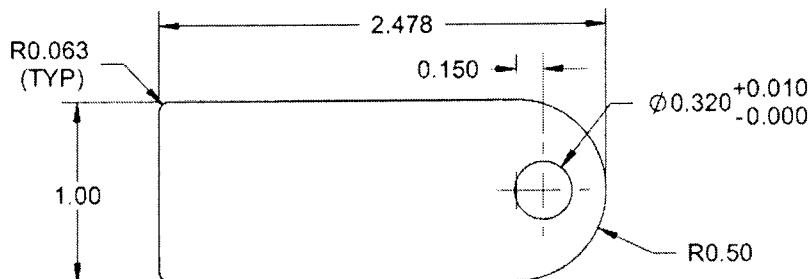
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|----------------------|-----------------------|---|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>RF</i> | APPROVED <i>RF</i> | DRAWING NO. D3437 |
| DATE 05.08.11 | | REV. B SHEET 2 OF 4 TITLE AFT STRUT ASSEMBLY SCALE 1:2 |

RELEASED

05.08.11 *RF*



D3437-3 CLIP
SCALE 1:1



D3437-3
FLAT PATTERN

11509

D3437-3 CLIP:

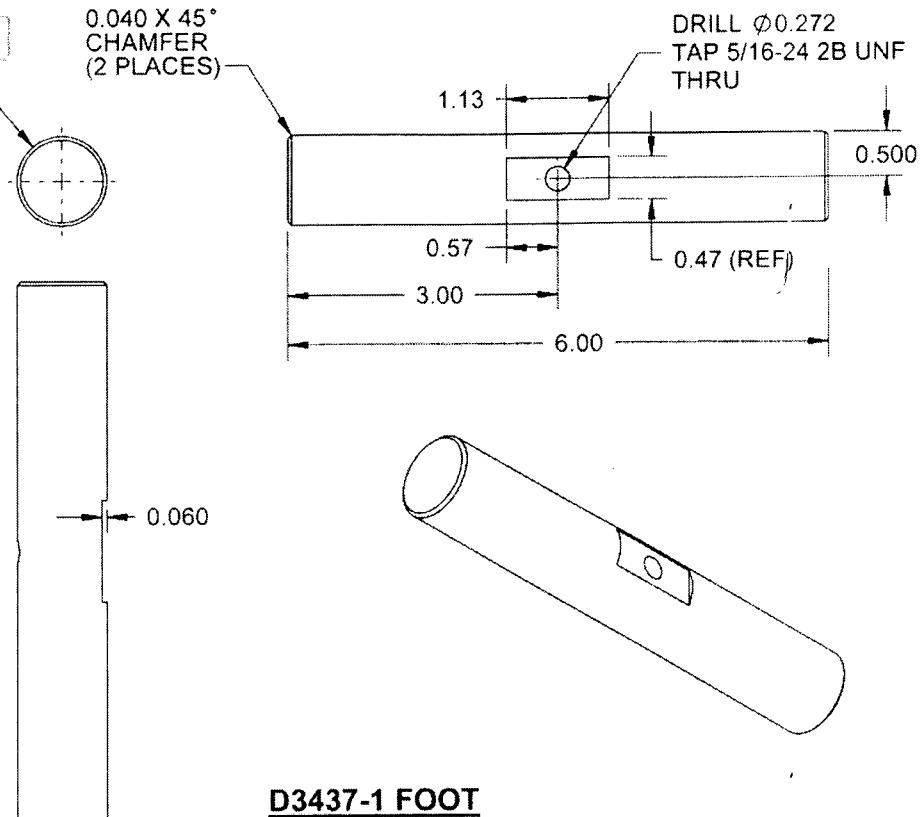
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



| | | | |
|----------------------|-----------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>MM</i> | APPROVED <i>MM</i> | DRAWING NO. D3437 | REV. B SHEET 3 OF 4 |
| DATE 05.08.11 | TITLE AFT STRUT ASSEMBLY | SCALE 1:2 | |

RELEASED

05.08.11 *MM*

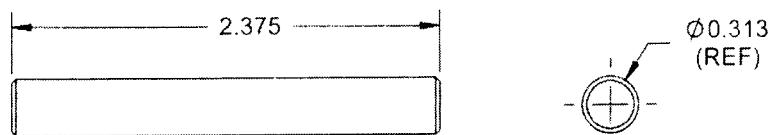


D3437-1 FOOT

D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

2/5/09



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

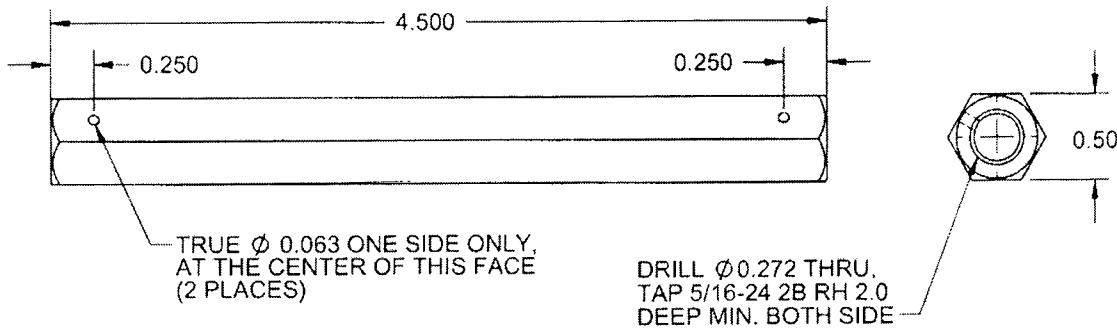
- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAUER P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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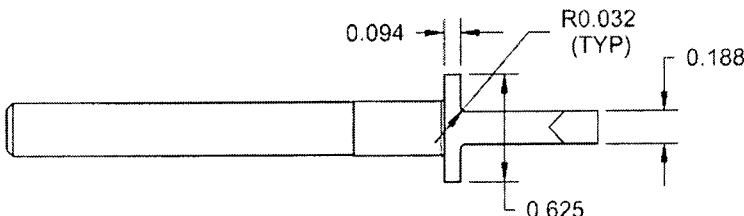


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|----------------------|-----------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RF</i> | APPROVED <i>RF</i> | DRAWING NO D3437 | REV. B SHEET 4 OF 4 |
| DATE 05.08.11 | TITLE AFT STRUT ASSEMBLY | SCALE 1:2 | |



D3437-5 STRUT:

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



RELEASED

05.08.11

